

# Work Order ID 72412

Monday, July 25, 2011 11:29:32 AM



Page 1

Item ID:	D3836-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib Assembly (Basket Lid, LH)					
Start Date:	7/25/2011	Start Qty:	2.00	Cust Item ID:		
Required Date:	7/29/2011	Req'd Qty:	2.00	Customer:		
Reference:						

Approvals:	Process Plan:	<i>M</i>	Date:	<i>11-07-25</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3836	Rev A								

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- cut D3836-1 and D3836-3 rib as per dwg D3836								

2- remove identification markings

3- deburr

4- weld D3836-1 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

5- weld D2327-3 spacer bushing as per dwg D3836  
A/R ER316 S.S. Rod Batch: *1114649*

6- grind weld flush where indicated on dwg

130	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

*Pl 11-08-23*

*(2) PMP 11/08/23*

*SAD 11-08-16*

*BE 11-08-23*

*2 φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72412**

Page 2

Monday, July 25, 2011 11:29:32 AM

Item ID: D3836-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 7/25/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

S w l o s / 23

20

Quality Control

150

Identify as per dwg & Stock Location: *B/C*

0.00



Packaging

Memo

0.00

Pl 11.08.23

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

n 18/24

Quality Control

11-08-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, July 25, 2011 11:29:38 AM

Page 1

Work Order ID: 72412

Parent Item: D3836-041

Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 7/25/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2327-3 Spacer Bushing		Manufactured	No			100	Each	16.0000	1	2		11/08/22	
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	Location	Loc Qty	Loc Code
M304TS0.750W.065 304 SQ Tube .75x.75x.065W	WA 71971	16	
		2	
		554.2282	1.7808
		3.749053	
			11-08-12

Location	Loc Qty	Loc Code
MAT018	77.6987	
117636	77.6987	
WA	441.0436	
118181	441.0436	
WA007	35.4858906	
116267	28.893172	
116763	6.5927186	

3.7491

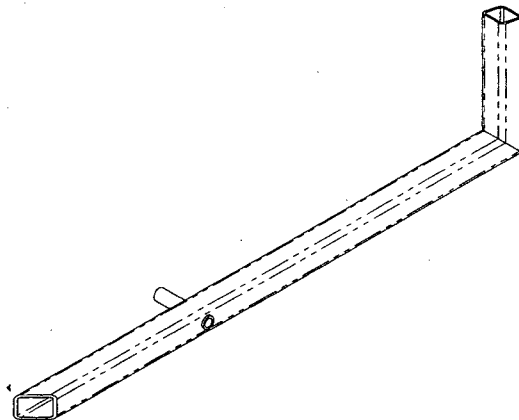
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

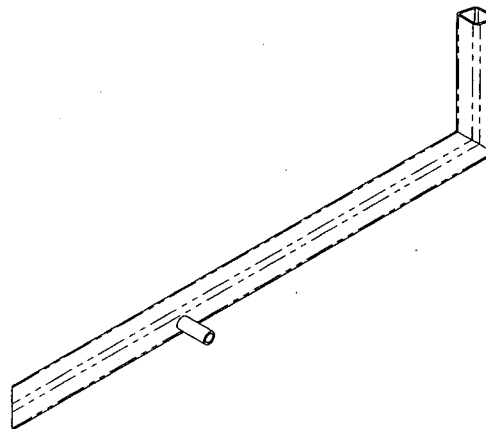
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3836-042 RIB ASSY (BASKET LID, RH)**



**D3836-041 RIB ASSY (BASKET LID, LH)**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs EACH
- 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 12412

*11/07/25*

**RELEASED**  
*08/11/25*

A	NEW ISSUE	MB	08.09.24
REV.		DESCRIPTION	BY DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	<i>AS-3</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3836	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY (BASKET LID)	NTS
DATE	08.09.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

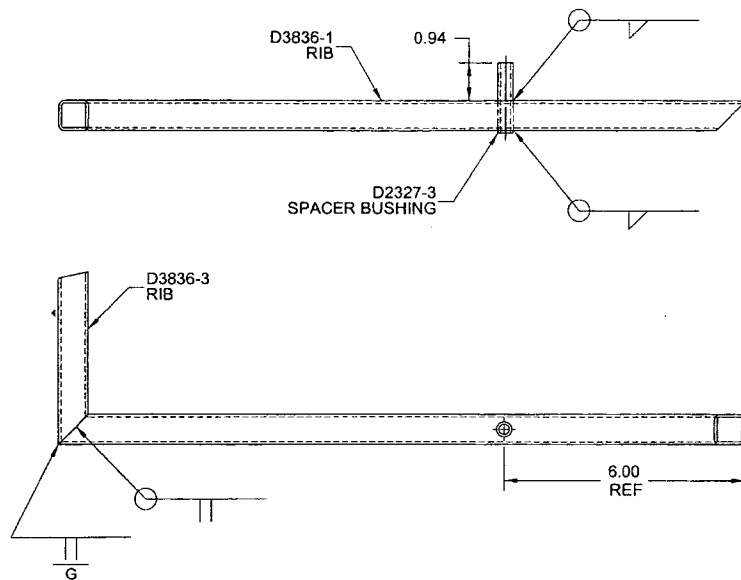
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

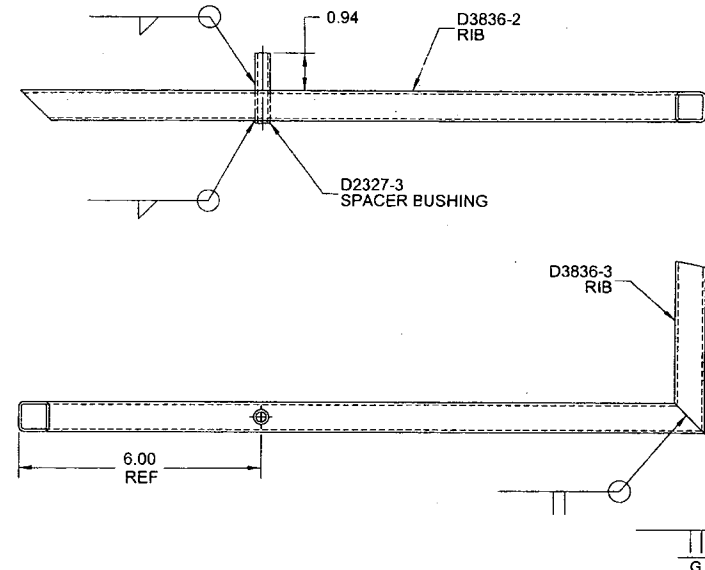
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D3836-041 RIB ASSY (BASKET LID, LH)**



**D3836-042 RIB ASSY (BASKET LID, RH)**

72412

**RELEASED**  
08/11/13

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

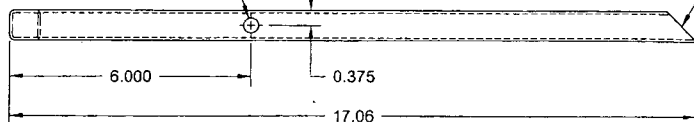
**NOTE:** Date & initial all entries

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CHAMFER

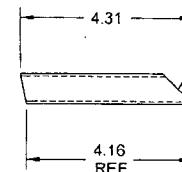


$\phi 0.375^{+0.020}_{-0.000}$  THRU

0.75 X 45°  
CHAMFER



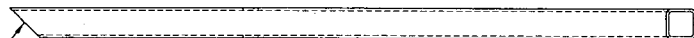
**D3836-1 RIB**



0.75 X 45°  
CHAMFER

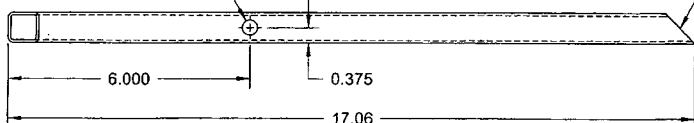
**D3836-3 RIB**

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CHAMFER

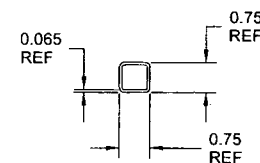


$\phi 0.375^{+0.020}_{-0.000}$  THRU

0.75 X 45°  
CHAMFER



**D3836-2 RIB**



**TYPICAL SECTION  
VIEW**

**RELEASED**  
*08/11/12*

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ASS</i>	DRAWING NO. <b>D3836</b>	REV. A
MFG. APPR.	<i>MP</i>	TITLE	SHEET 3 OF 3
APPROVED	<i>CH</i>	<b>RIB ASSY (BASKET LID)</b>	SCALE
DE APPR.			NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries